

Work Order ID 81610

81610

Page 1

March-16-12 8:37:08 AM

Item ID: D058-677-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step LH

Stop

NS2

Start Date: 16/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/16

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2943

RevC

100

0.00

100

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD058-677-011

CHG 002

5/12/07/10

110

0.00

110

Large Fab

Memo

0.00

Large Fab

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

2-Deburr and bevel ends for welding

3-Weld end cap(1) and mounting plates as per Dwg D2943

A/R AL ROD

Batch: 120854

4-Grind end cap welds flush as per dwg D2943

2 Ø Ac 12.05.23
12.06.13

2 Ø Ac 12.06.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81610

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

2

2

Reference:

Run Start *NR1*

Stop ***NR2***

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
------------	------------	---------------	-------------

0.00

120

0.00

Quality Control

0.00

130

0.00

Quality Control

0.00

140

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item Name: Heli-Access-Step LH

Stop ***NS2***

Start Date: 16/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

2

0

12.07.03

160

0.00

160

Large Fab

Memo

0.00

Large Fab

1-Weld last end cap(1) as per Dwg D2943 using Jig DT 8482
A/R AL ROD Batch: 120854

2-Grind end cap welds flush as per dwg D2943

2

0

12.07.03

12.07.03

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

8/7/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item Name: Heli-Access-Step LH

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Start Date: 16/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									
190		0.00							
190									
HandFinish	Memo	0.00							
Hand Finishing	1-Pressure wash as per QSI 005 2-Touch up Chemical Conversion Coat as per QSI 005 4.1								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
200									
Powdercoat	Memo	0.00							
Powder Coating									

M121841

Start Time: 8:30
Temp: 320°F
Finish Time: 9:00

2 246 12.73

M/L
12/07/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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2

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Required Date: 30/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Wing Walk as per dwg QSI005 4.4 Batch 121613

0.00

210

HandFinish

Memo

0.00

Hand Finishing

2 ~~2~~ ~~2P~~ 12/07/11

220

QC3- Inspect Part Finish

0.00

220

QC

Memo

0.00

Quality Control

12/07/11

230

QC5- Inspect part completeness to step on W/O

0.00

230

QC

Memo

0.00

Quality Control

CK 12/7/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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N900040100Setup Start ***NS1***

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Stop ***NS2***

Item Name: Heli-Access-Step LH

Start Date: 16/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Pick Kit

0.00

240

Packaging

Memo

0.00

Packaging

2 12/07/06 JB

241

QC4- 100% Inspect kits for completeness

0.00

241

QC

Memo

0.00

Quality Control

8/12/07/10

⑦

250

0.00

250

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D058-677-011

Location:

PPP Rev: C

2x 82 12-7-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 81610

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Item ID: D058-677-011

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step LH

Stop ***NS2***

Start Date: 16/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept Reject Reject Insp.
Qty Qty Number Stamp

260

QC21- Final Inspection - Work Order Release

0.00

260

QC

Memo

0.00

Quality Control

OK 12/7/11 2'

R12-07-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

March-16-12 8:37:11 AM

Page 1

Work Order ID: 81610

81610

Parent Item: D058-677-011

D058-677-011

Parent Item Name: Heli-Access-Step LH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:B01.04.11Combined with D2943-041EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

110

Each

68.7300

1

2

D2622-120C

Step Extrusion

**

B81507 (2) Ac 12.05.23

Location

Loc Qty

Loc Code

HALL

16.37

46910

2

64409

6

66970

7.7

68293

0.25

72131

0.42

WA013

52.36

75781

2.4

77612

49.96

D2734

Manufactured

No

110

Each

109.0000

2

4

D2734

Step End Plate

**

12.07.03

Location

Loc Qty

Loc Code

WA

B83322 = 2

109

76985

49

80682

60

B84563 = 2

110

Each

11.0000

2

4

D3458-1

Manufactured

No

D3458-1

Step Mounting Plate

**

12.06.14

Location

Loc Qty

Loc Code

WA002

B82117

10

75609

10

WA018

1

63075

1



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 81610

Parent Item: D058-677-011

Parent Item Name: Heli-Access-Step LH

81610

D058-677-011

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

D3458-3 Manufactured No

110 Each

21.0000 2 4

D3458-3

Step Mounting Plate

**

12.06.14

Location

Loc Qty

Loc Code

WA002

382116

21

75610

21

D2731-3 Manufactured No

240 Each

80.0000 2 4

D2731-3

Mounting Lug

**

JB

Location

Loc Qty

Loc Code

ST469

80

73417

80

D3394-043 Manufactured No

240 Each

48.0000 2 4

D3394-043

Lug Assembly

**

73417

80217 JB

Location

Loc Qty

Loc Code

ST479

48

69180

12

71082

1

72520

1

78921

34

D2732-030 Manufactured No

240 Each

9.0000 8 16

D2732-030

Rubber Cushion

**

83560 JB

12/07/06

Location

Loc Qty

Loc Code

ST402

9

76850

3

78144

6

March-16-12 8:37:12 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 81610

Parent Item: D058-677-011

Parent Item Name: Heli-Access-Step LH

81610

D058-677-011

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

D3394-041

Manufactured No

240 Each

40.0000

D3394-041

Lug Assembly

** 2

4

JB

Location

Loc Qty

Loc Code

ST479

40

74505

40

240 Each

152.0000

Purchased No

AN4-14A

AN4-14A

Bolt

** 8

16

74505
12x121349
4x122141

JB

Location

Loc Qty

Loc Code

ST357

152

118451

5

119798

84

120187

13

120769

50

240 Each

18.0000

Manufactured No

D2731-7

D2731-7

Mounting Lug

** 2

4

78922

JB

12/07/06

Location

Loc Qty

Loc Code

ST

-50

ST468A

18

69177

12

71083

2

71860

4

ST469

50

March-16-12 8:37:12 AM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D058-677-011

D058-677-011

Parent Item Name: Heli-Access-Step LH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

AN4-15A

Purchased

No

240

Each

375.0000



8

✓

**

122141 JB

AN4-15A

Bolt

Location

Loc Qty

Loc Code

GA

100

120449

100

ST358

275

118706

15

120187

60

120422

200

AN960JD416

NAS1149D04631, Purchased

No

240

Each

14.0000



24

✓

**

121912 JB

AN960JD416

Washer

Location

Loc Qty

Loc Code

ST351

14

116289

14

MS21042L4

Purchased

No

240

Each

5,527.000



24

✓

**

121444 JB 12/07/06

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

5527

117441

51

117601

157

118451

133

119017

200

119075

2986

121011

2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

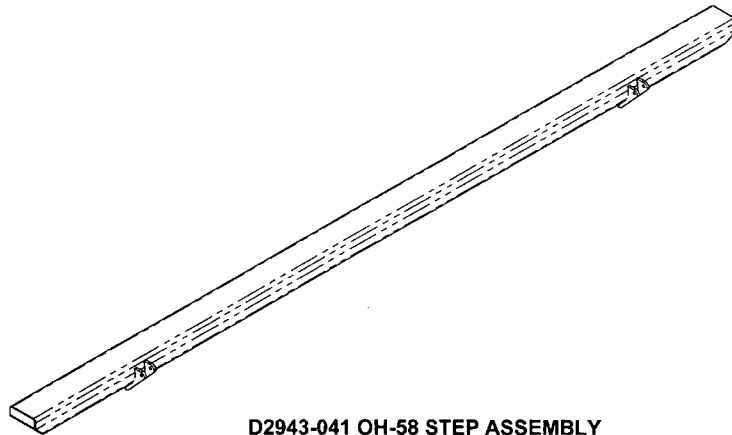
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

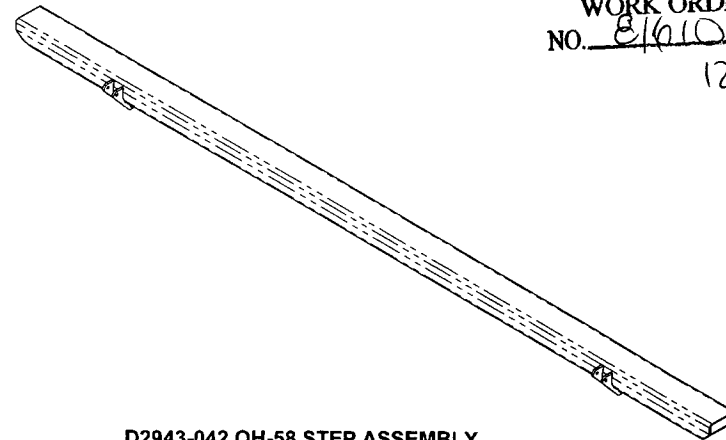
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ITEM No.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D2943-041	OH-58 STEP ASSEMBLY, LH
2		X	D2943-042	OH-58 STEP ASSEMBLY, RH
7	1	1	D2943-1	STEP
11	2	2	D2734	END PLATE
12	2	2	D3458-1	STEP MOUNTING PLATE
13	2	2	D3458-3	STEP MOUNTING PLATE



D2943-041 OH-58 STEP ASSEMBLY



D2943-042 OH-58 STEP ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81010 MJS
12/03/16

RELEASED
09/06/25 MJS

D2943-041/-042 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.31 lbs
- 8) WELD PER QSI 004

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. ATTACHMENT CHANGED FROM SINGLE LUG TO DOUBLE LUG. D2725 REPLACED BY ITEMS 12 & 13 REASON: SEE PAR 152. ADDED ITEM 7, D2622-082 MOVED FROM P/L TO NOTES ON SHEET 3.	AJS	08.11.17
B	UPDATED FINISHING NOTE	PH	05.11.14
A	NEW ISSUE	RF	99.11.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2943	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		OH-58 STEP ASSEMBLY	NTS
DATE	08.11.17	COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

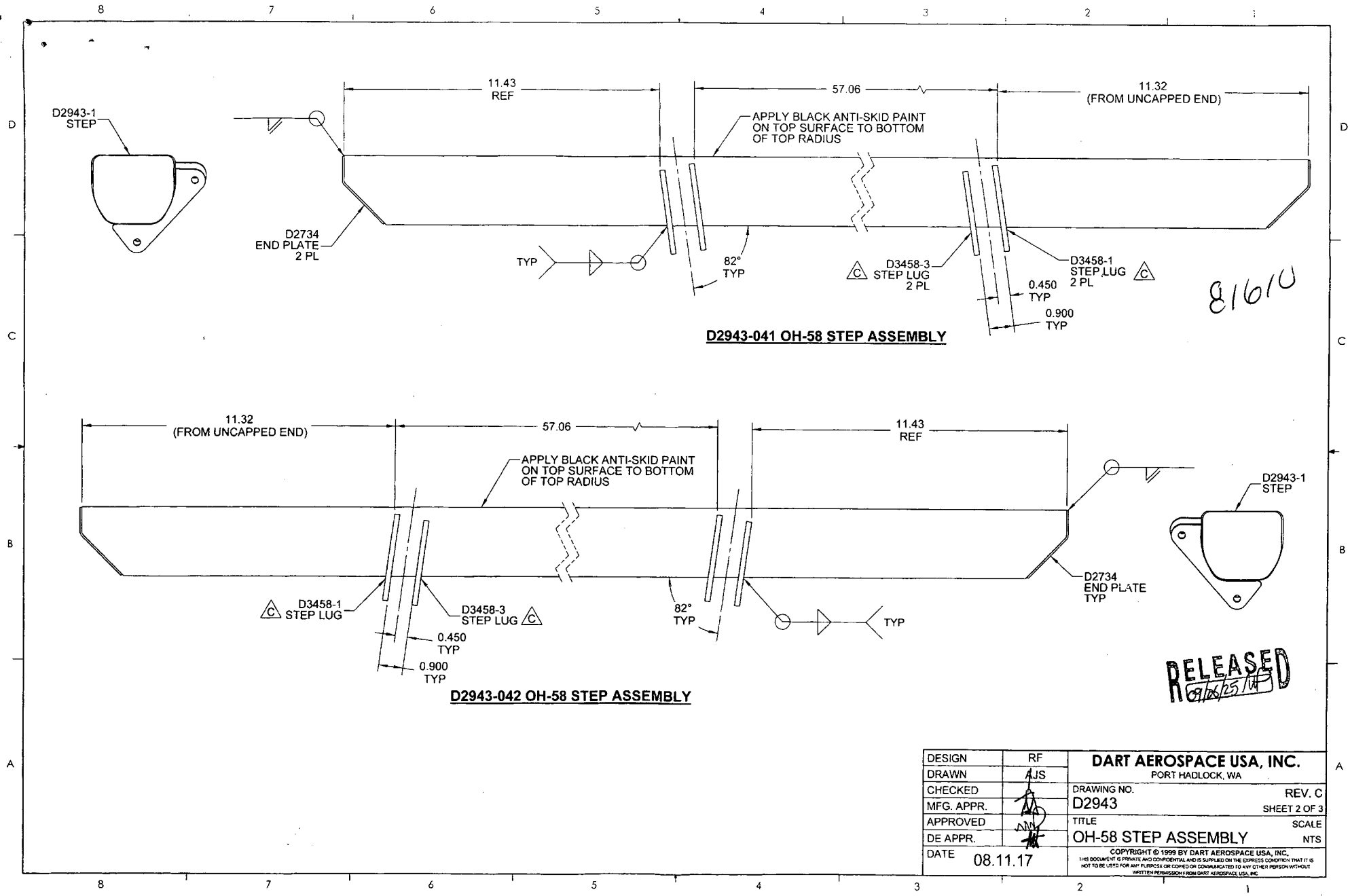
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



81610

RELEASED
9/26/25/14

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D2943	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OH-58 STEP ASSEMBLY	NTS
DATE	08.11.17	<small>COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

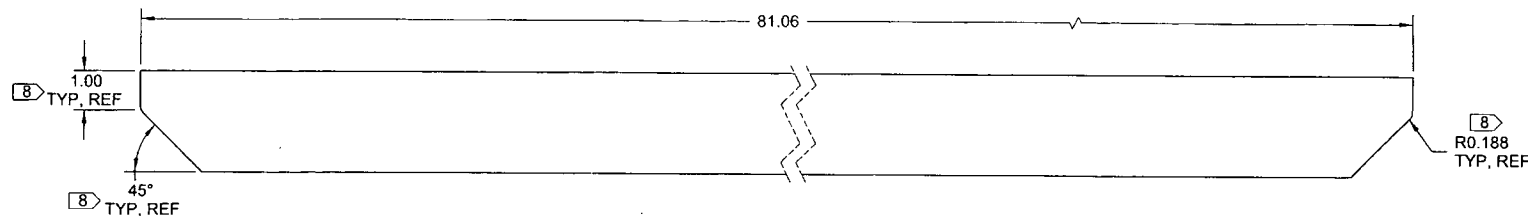
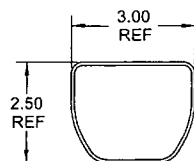
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

01010



D2943-1 STEP

D2943-1 NOTES:

- 1) MATERIAL: MAKE FROM D2622-082 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 5.93 lbs
- 8) SHAPE TO FIT D2734 END CAP

RELEASED
01/06/25/17

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO. D2943	REV. C SHEET 3 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED	NN	OH-58 STEP ASSEMBLY NTS	
DE APPR.			
DATE	08.11.17	<small>COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 PARTS LIST:

Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
X				D058-677-011	HELI-ACCESS-STEP™, LH
	X			D058-677-012	HELI-ACCESS-STEP™, RH
		X		D058-677-013	HELI-ACCESS-STEP™, LH
			X	D058-677-014	HELI-ACCESS-STEP™, RH
1		1		D2943-041	STEP ASSEMBLY LH
	1		1	D2943-042	STEP ASSEMBLY RH
		2	2	D3394-045	MOUNTING LUG (REPLACES D2230-1)
		2	2	D2230-3	MOUNTING LUG
/ 2	2			D3394-041	MOUNTING LUG (REPLACES D2731-1)
/ 2	2			D2731-3	MOUNTING LUG
/ 2	2	2	2	D3394-043	MOUNTING LUG (REPLACES D2731-5)
/ 2	2	2	2	D2731-7	MOUNTING LUG
/ 8	8	8	8	D2732-030	RUBBER CUSHION
/ 8	8	4	4	AN4-14A	BOLT
/ 4	4	4	4	AN4-15A	BOLT
		4	4	AN4-16A	BOLT
/ 12	12	12	12	AN960JD416	WASHER
/ 12	12	12	12	MS21042L4	NUT (OR MS21042-4)

5.0 WEIGHT AND BALANCE:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D058-677-011/-013 HELI-ACCESS-STEP™, LH	8.15 lb 3.70 Kg	- 36.5 in - 0.93 m	- 297.5 in-lb - 3.30 m-kG	100.44 in 2.55 m	818.6 in-lb 9.44 m-kG
D058-677-012/-014 HELI-ACCESS-STEP™, RH	8.15 lb 3.70 Kg	+36.5 in +0.93 m	+297.5 in-lb +3.30 m-kG	100.44 in 2.55 m	818.6 in-lb 9.44 m-kG

Work Order ID 81610

March-16-12 8:37:08 AM

81610

Page 1

Item ID: D058-677-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step LH

Start Date: 16/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/03/12* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2943	RevC
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100	0.00
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100

DC	0.00
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Document Control Memo Photocopy bluefile & type labels per PPPD058-677-011 CHG 002

CL 12/07/04

110	0.00
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110

Large Fab	0.00
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Large Fab Memo 1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

2-Deburr and bevel ends for welding

3-Weld end cap and mounting plates as per Dwg D2943
A/R AL ROD Batch: *120854*

4-Grind end cap welds flush as per dwg D2943

2

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*Ac 12.05.23
11/12.06.13*

2

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Ac 12.06.20